

Ship 20/01!

Work Order ID 111235

January-09-14 12:53:37 PM

D 4647-3

111235

Page 1

Item ID: D4647-3

B 111235

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 09/01/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

APM

Date: 14-01-09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4647

B

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-CUT AS PER DWG

DWG REV: 6

PROG REV: 13

2- Deburr

8 0 Jm14-01-15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

8 0 Jm14-01-15

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Page 2

Item ID: D4647-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 09/01/2014 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 27 9-89 0.00 14/1/15				8			
140 *140* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		DAS 30 9-89		8			14/1/15
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 27 9-89 0.00 14/1/15				8			

Work Order ID 111235

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111235

Page 4

Item ID: D4647-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 09/01/2014 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

1/14-01-17
M 14-01-17

Picklist Print

Page 1

January-09-14 12:53:41 PM

Work Order ID: 111235

111235

Parent Item: D4647-3

D4647-3

Parent Item Name: Doubler

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.08.29 NEW ISSUE DD VERF:JFS
13.07.17 AS PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

110

sf

251.9500

0.45

4

M6061T6S 040

**

Jm14-01-15

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

251.95

m126350

96

m126981

155.95

126350

8 7 6 5 4 3 2 1

D

D

C

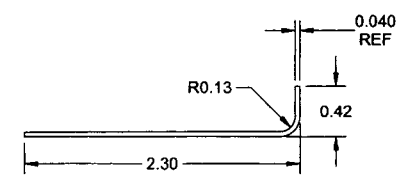
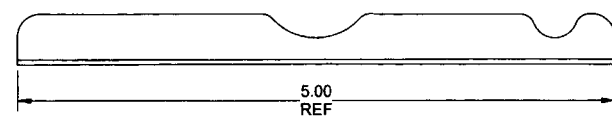
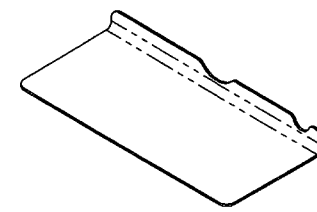
C

B

B

A

A







D4647-3 DOUBLER 

111235 MP
14-01-09

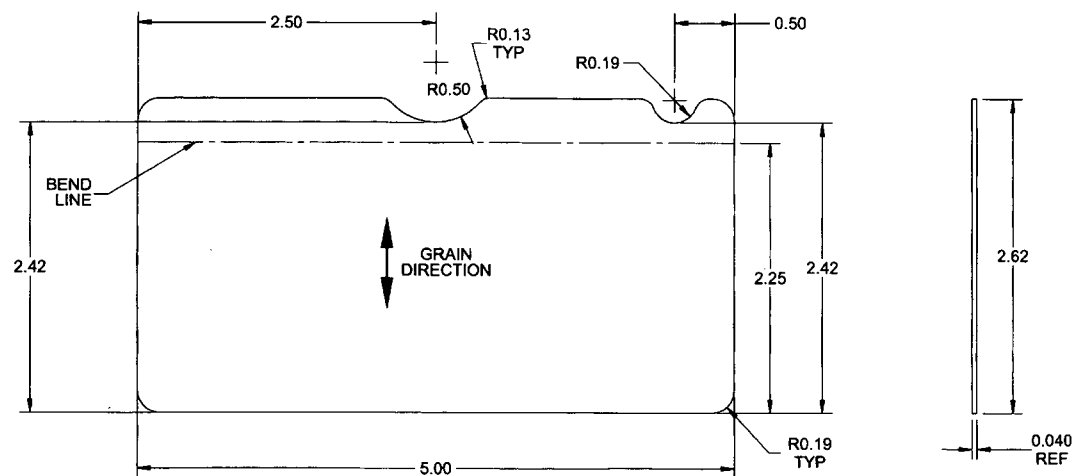
RELEASED
2013-07-15


NOTES:

- 1) MATERIAL: MAKE FROM D4647-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4647	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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8 7 6 5 4 3 2 1



D4647-3F FLAT PATTERN DOUBLER

RELEASED
2013-07-15
MP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO. D4647	REV. B
MFG. APPR.	<i>NS</i>	SHEET 4 OF 8	
APPROVED	<i>SH</i>	TITLE DOUBLER	SCALE NTS
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